

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. G AND D204-635 REV. G OR EARLIER, AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 4 AND D204-635 REV. 4 OR EARLIER
REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

1.0 PURPOSE:

TO PROVIDE A REPAIR FOR CRACKED D2579 SADDLE SPACERS IN EARLY MODEL D205-634-011 AND D204-635-011 SKIDTUBES.

2.0 PROCEDURE:

- 1) REMOVE THE AFFECTED SKIDTUBE(S) IN ACCORDANCE WITH ICA-D205-634 / ICA-D204-635 CHAPTER 32.1 AND PLACE ON A SUITABLE WORK SURFACE.
- 2) CLEAN THE AFFECTED AREA OF PAINT, OLD SEALANT, ETC.
- 3) DRILL OUT THE DAMAGED SPACER(S) USING A Ø 0.500" DRILL ON BOTH SIDES AND DEBURR HOLES TO REMOVE ALL SHARP EDGES. TO PREVENT THE SPACER FROM FALLING INTO THE SKIDTUBE, IT IS RECOMMENDED THAT IT BE HELD WITH A SET OF PLIERS AFTER ONE SIDE HAS BEEN DRILLED OUT.
- 4) CHAMFER SPACER HOLES 0.050" X 45° ON BOTH SIDES OF THE SKIDTUBES.
- 5) TOUCH UP HOLES WITH CHEMICAL CONVERSION COATING IN ACCORDANCE WITH MIL-DTL-5541.
- 6) INSTALL D4981-1 SPACER USING MAGNOBOND 6398, ALLOW ADEQUATE TIME FOR MAGNOBOND 6398 TO CURE, AND GRIND FLUSH.
- 7) TOUCH UP FINISH WITH ONE COAT OF MIL-P-85582 OR MIL-P-23377 PRIMER, AND 2-3 COATS OF MIL-C-83285 POLYURETHANE COAT TO MATCH ORIGINAL FINISH AS REQUIRED.
- 8) REINSTALL SKID(S) IN ACCORDANCE WITH ICA-D205-634 / ICA-D204-635 CHAPTER 32.2.

3.0 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9675-011	CROSSBOLT SPACER REPAIR KIT
8	D4981-1	SPACER

4.0 WEIGHT AND BALANCE:

THERE IS A NEGLIGIBLE WEIGHT AND BALANCE CHANGE ASSOCIATED WITH THIS MODIFICATION.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9675	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER REPAIR KIT	NTS
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